

Work Order ID 56808

March 10, 2010 1:30:37 PM

Page 1

Item ID: D350-589-042

Accept

Revision ID:

Item Name: Side Door Assembly RH

Start Date: 10/03/2010 Start Qty: 1.00

Required Date: 18/03/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: RT

Date: 10-3-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2991

D

DSI 9463

A

IIN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-042/ DSI 9463
CHG005

8 10/05/06

48 for BG 10/05/06

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

85 10 05 04

Pho →

Dart Aerospace Ltd

W/O: 56808		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/08	# 110.1	Perm Change Trim AS Return to fit mock up Helicopter -Prime + Paint as necessary per AS7005	ET ER	10.05.03 10.05.07			J 10/04/08

Part No: D350-589-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly RH

Stop



Start Date: 10/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

25 10-05-04

(40)

10-5-65

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

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Required Date: 18/03/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

5/16/05/06

47
RH

Pho →

180



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-589-042/ DSI 9463

Location: _____
PPP rev: 12

0.00

0.00

10/05/06

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/05/07
MF
10-5-6

Dart Aerospace Ltd

W/O: 56808		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/06	100	Perm. Change Part mission ADD to Kits S-D3875-1 B*46897 qty x1 S-D3894-1 B*46896 qty x1	SP	10-5-06			S 10/05/06
		wp Data w/o + Bom Per DSZ 7447 + 7446 ADD copy w/ new Bom As Ref.	ER	10-05-07			S 10/05/06

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Picklist Print

March 10, 2010 1:30:41 PM

Page 1

Work Order ID: 56808

Parent Item: D350-589-042

Parent Item Name: Side Door Assembly RH



Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

D2991-2	Manufactured	No	110	Each	0.0000	1.0000	
							
Side Door							
D2621	Manufactured	No	110	Each	55.0000	3.0000	
							
Latch Plate, 350 Spacepod							

B 56810

BT 10-04-28

BT 10-05-04

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

55

46842

55

D2586

Manufactured No

110

Each

100.0000

3.0000



Door Latch

x3

BT 10-05-04

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

96

45554

1

50213

4

55314

91

x3

Main Warehouse

ST204

4

56416

4

W/O:		WORK ORDER CHANGES					
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March 10, 2010 1:30:42 PM

Page 2

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 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

110

Each

159.0000 1.0000



Screw



21 10-05-04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

159

112794

59

114056

100

x3

D2464-1700

Manufactured

No

110

Each

0.0000 1.0000



Neoprene Seal

348173



21 10-05-04

D3085-041

Manufactured

No

110

Each

6.0000 1.0000



prop ass'y



21 10-05-04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

47186

2

47687

4

x1

March 10, 2010 1:30:42 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
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 verified : DD

Start Qty: 1.00

Required Qty: 1.00

D2585 Manufactured No 110 Each 73.0000 3.0000



Mounting Channel



EC 10-05-04

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST018

73

53798

13

55313

60

MS21042L3

Purchased No

110

Each

2,353.000

3.0000



23

EC 10-05-04

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

2353

110844

35

111274

27

111668

58

112314

285

112385

228

113523

20

113537

700

113644

1000

AN960JD10

Purchased No

110

Each

0.0000

3.0000



23

EC 10-05-04

Washer

m 114292 x3

14A51149 003635

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-S

Purchased No 160 Each 1,717.000 6.0000



Rivet, Universal Head



105-6 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST319

1717

111916

1717

Purchased No

160 Each

1,920.000 6.0000

AN3-4A



Bolt



6

105-6 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST350

1920

104214

393

104291

300

104322

200

104374

200

104625

300

104817

527

6

March 10, 2010 1:30:42 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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March 10, 2010 1:30:42 PM

Page 5

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Parent Item Name: Side Door Assembly RH

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IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
verified : DD

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

D2237



Striker Plate

Manufactured No 160 Each 63.0000 1.0000



10-5-6 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST010 63

55006 16

55312 47

D2589



Keys, Key Chain, B50 Hinge

MS2104213



Nut

Manufactured No 160 Each 0.0000 1.0000



58194 sl 10-5-6

Purchased No 160 Each 2,353.000 6.0000



10-5-6 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300 2353

110844 35

111274 27

111668 58

112314 285

112385 228

113523 20

113537 700

113644 1000

6

March 10, 2010 1:30:42 PM

Shop Packet Print

Page 5

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56808
B-10-3-10

RELEASED
2009-10-30
M

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X-X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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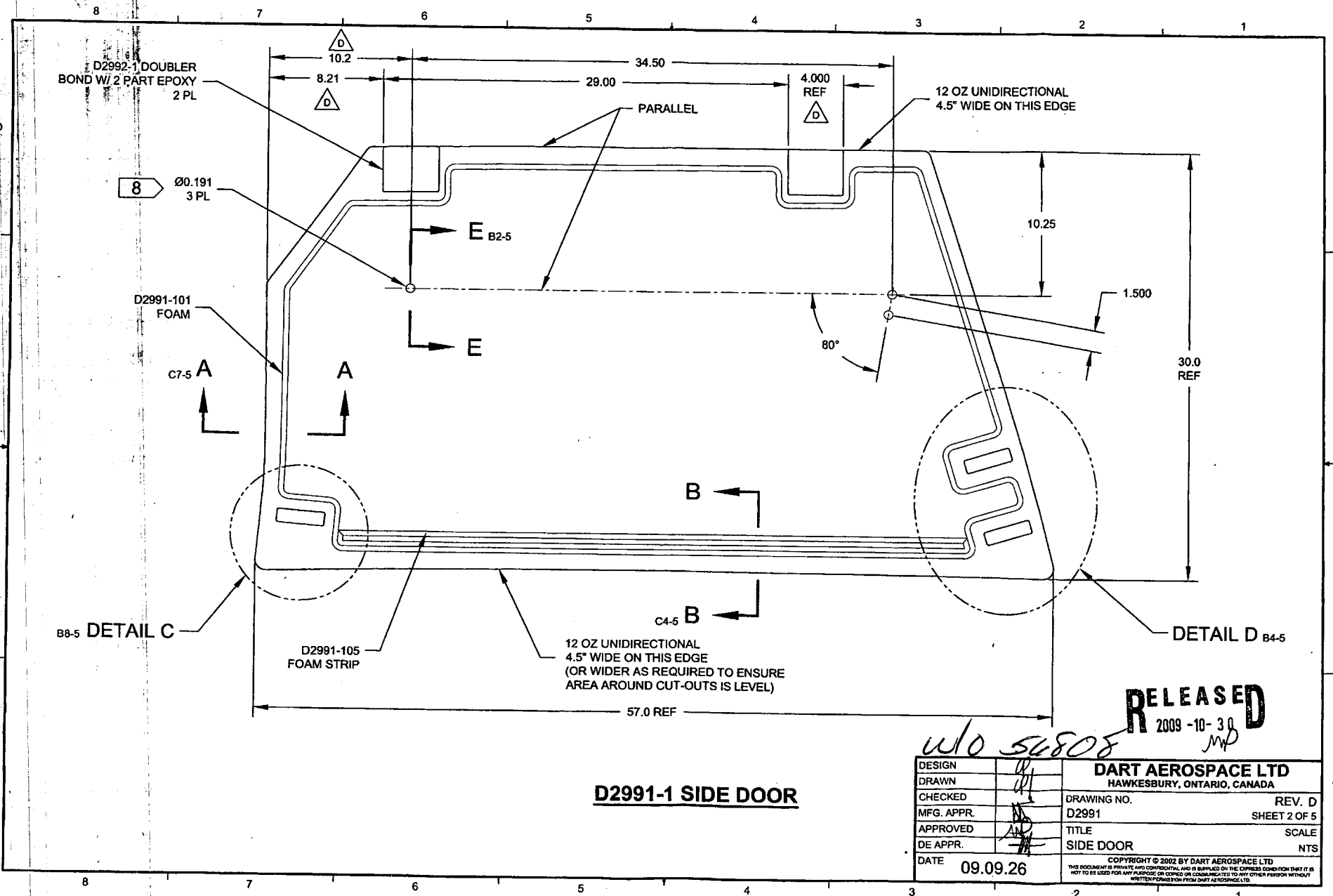
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NOTE: Date & initial all entries



D2991-1 SIDE DOOR

RELEASED
2009-10-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

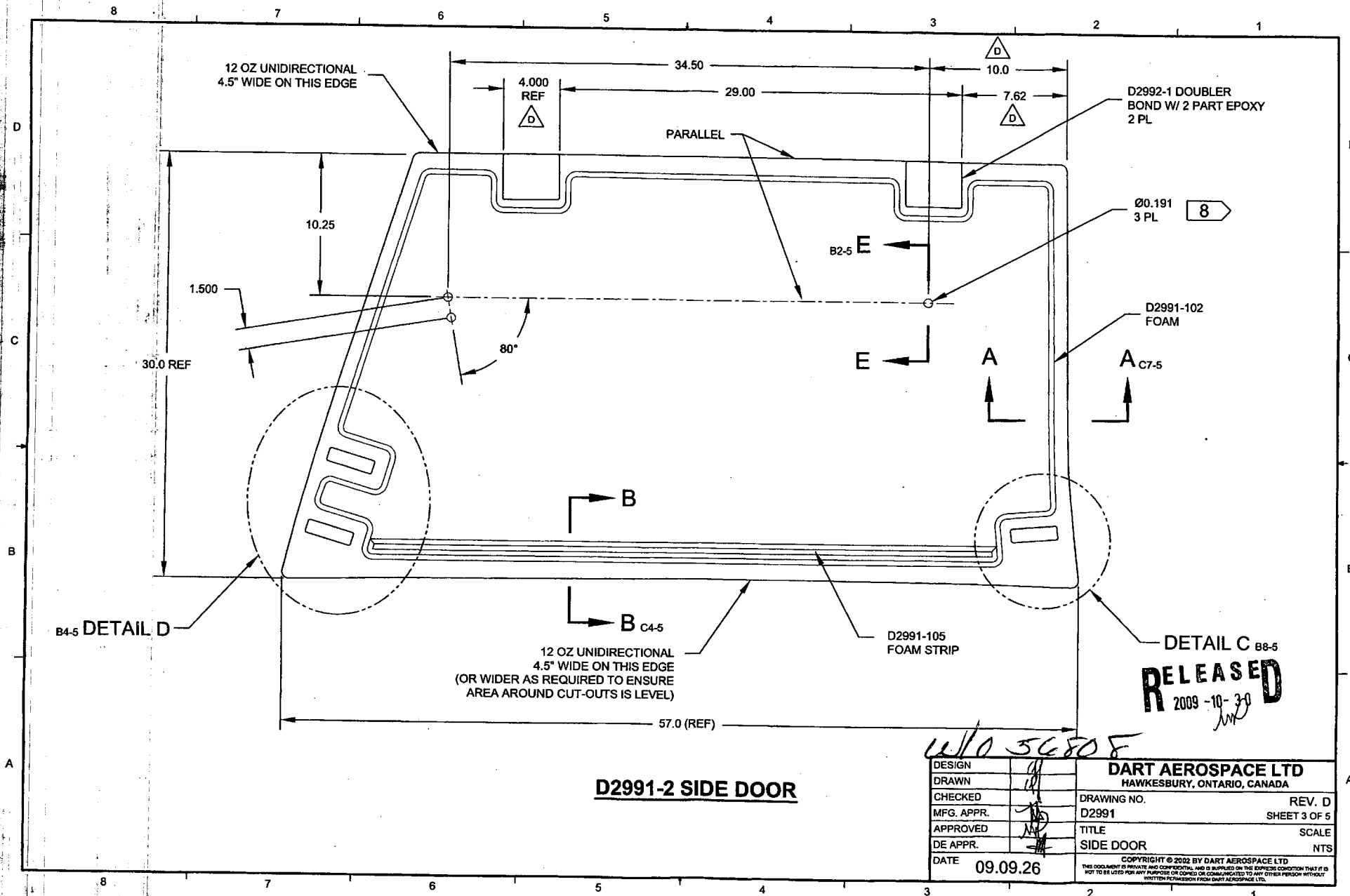
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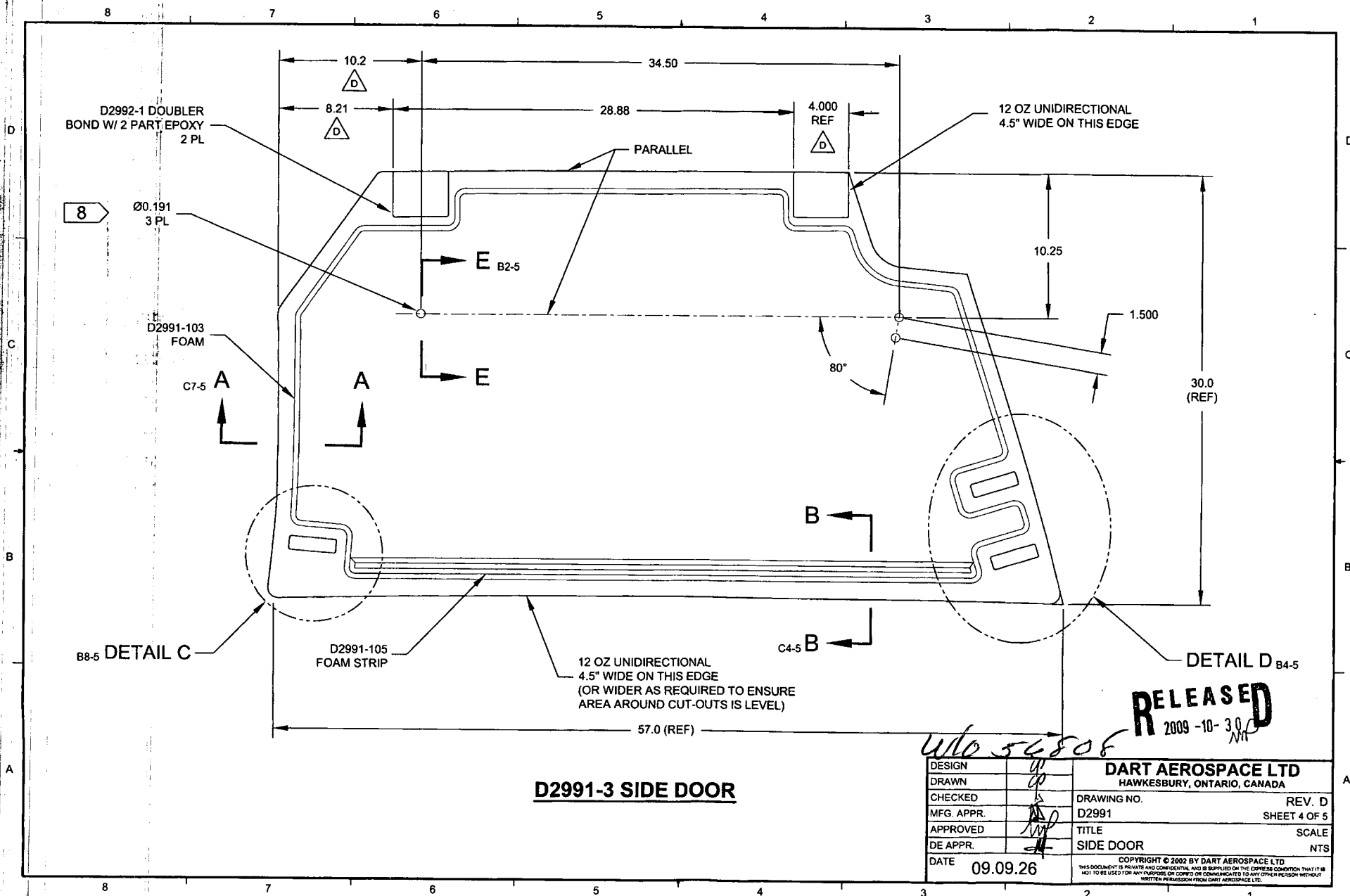
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RELEASED
2009-10-30

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	MP	D2991	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

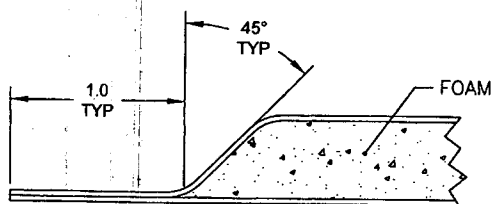
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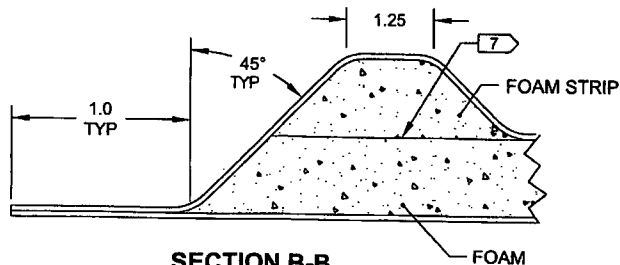
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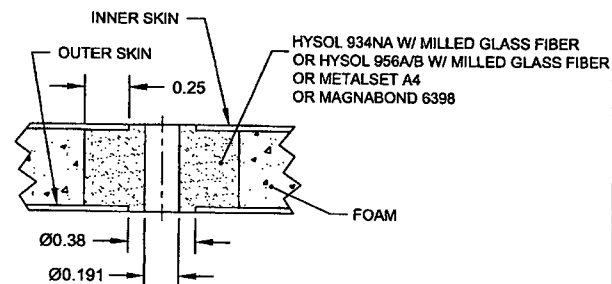
NOTE: Date & initial all entries



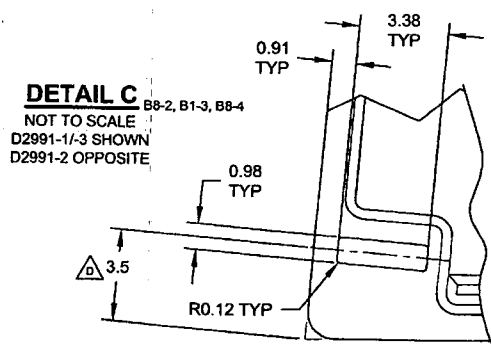
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



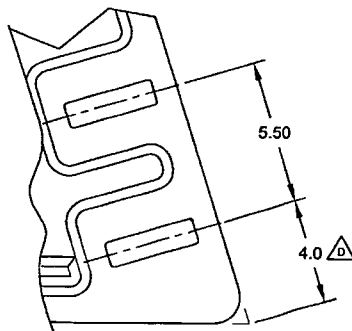
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2009-10-30
JMM

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D2991 SHEET 5 OF 5
APPROVED		TITLE SCALE
DE APPR.		SIDE DOOR NTS
DATE	09.09.26	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O 56908

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E
AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1
REF CANADIAN STC: SH92-41
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

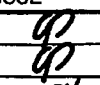
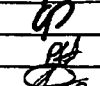
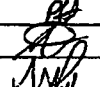
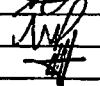
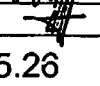
Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.05.26
CERT. NO.: SH92-41
ISSUE NO.: 8

A	NEW ISSUE	CP	09.05.26
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9463	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR MODIFICATION	NTS
DATE	09.05.26	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/0-54808

To install the DSI-9463-011 Door Latch Kit:







- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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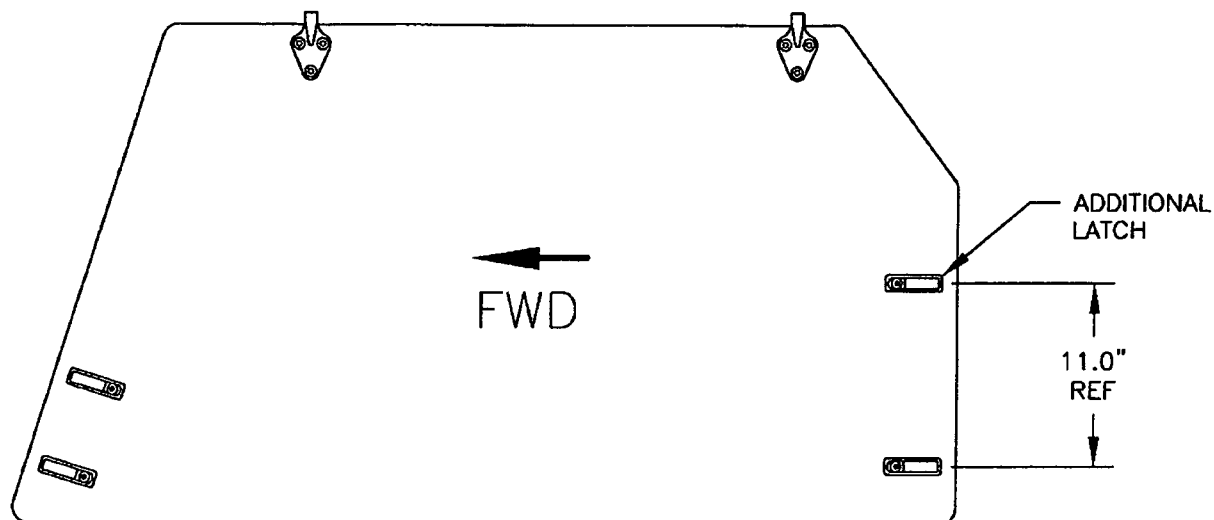
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W10-56808









**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)
D35X-589-042/-043 (SIMILAR)**

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DAO # 01-O-01

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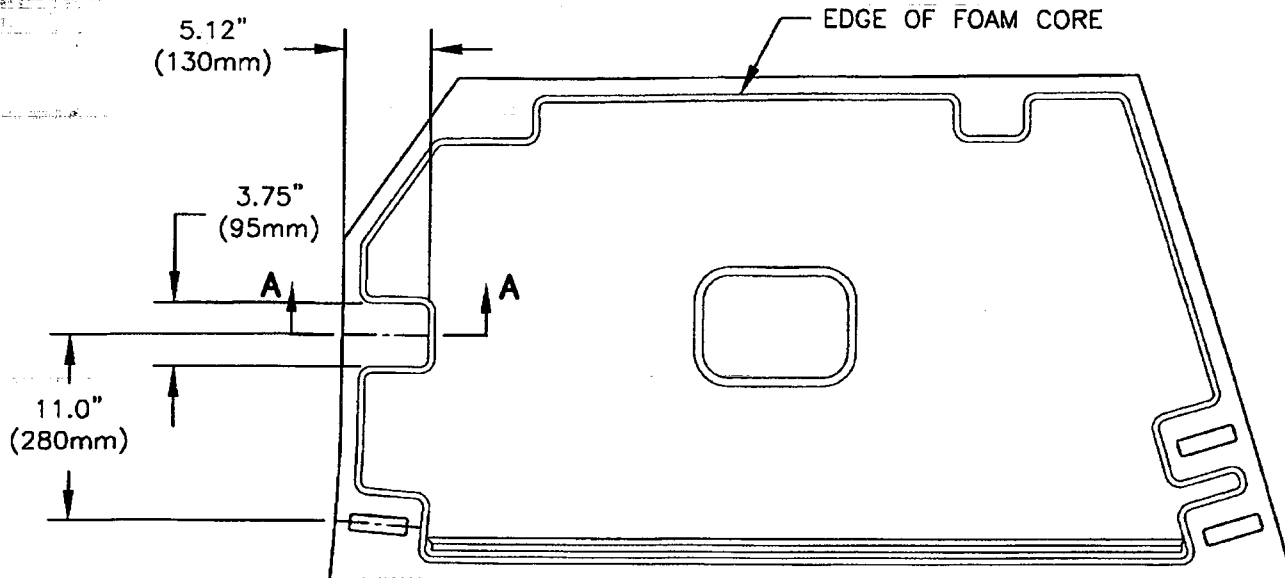
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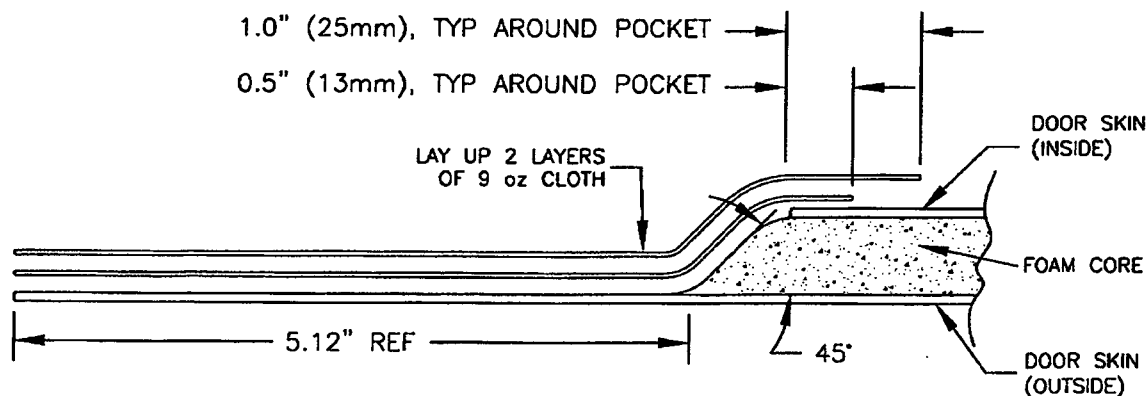
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

WLO 54808



**FIGURE 2: TRIMMING FOAM CORE
(VIEW LOOKING AT INSIDE OF DOOR)
(-041 SHOWN. -042/-043 SIMILAR)**



SECTION A-A

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DAO # 01-O-01

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MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 4 OF 5
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/054808

SEE
DETAIL B

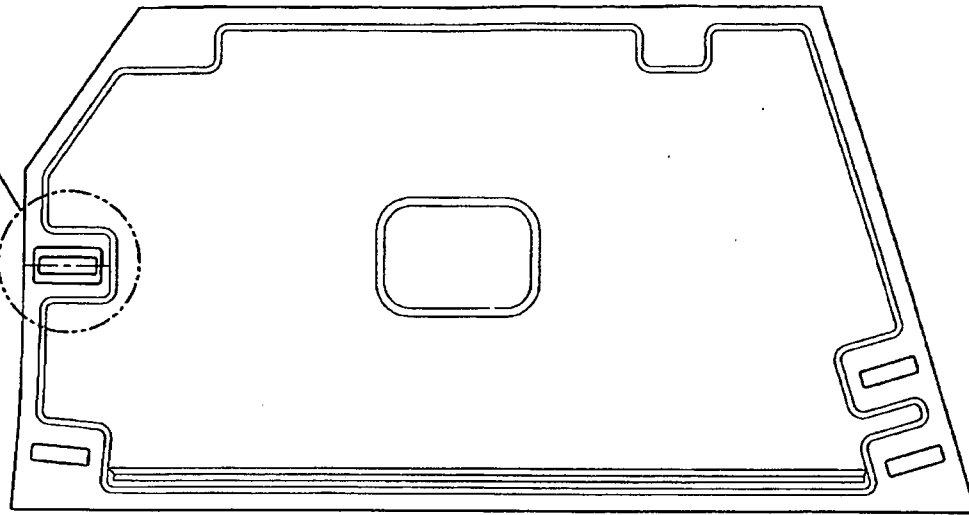
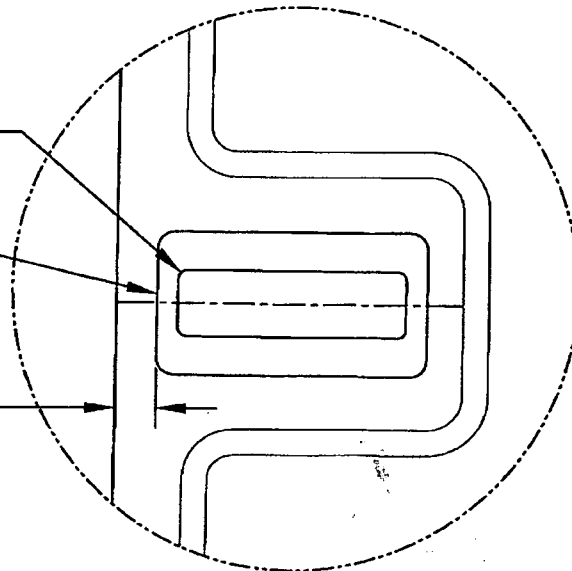


FIGURE 3: CUTTING LATCH HOLE

CUT HOLE THROUGH
SKIN USING D2621 AS
TEMPLATE

D2621 LATCH PLATE

0.60"
(15.2mm)



DETAIL B

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DEPARTMENT OF TRANSPORT
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DAO # 01-O-01

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MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -041	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
				D2583	Latch Bracket
	3	3	3	D2585	Latch Clamp
	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
	3	3	3	AN960JD10	Washer
	9	9	9	MS21042L3	Nut (or MS21042-3)
	6	6	6	MS20470AD4-5	Rivet
	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x Ø0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes Ø0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

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BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
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A	NEW ISSUE	09.02.04
REV.	DESCRIPTION	BY DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
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MFG. APPR.	N/A	DSI 9447 SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT NTS
DATE	09.02.04	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x Ø0.129 (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

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A	NEW ISSUE	<i>[Signature]</i>	09.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9446	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SWITCH RELOCATION	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries